Work Orde Tuesday, March				*98	N49*		: :		Ship.	Honn	Page	1
Revision ID:	D4005-041 Fwd Floor Gutt	ter		Accept	*N900	04N	100)*	Setup Star Stop	I ZI	S1* S2*	
Start Date: Required Date: Reference:	3/5/2013 3/13/2013	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:		in A	•			
Approvals:	Process Plan QC:	n: MC	Date: \\ 3-3-5 Date:	Tooling: SPC (Y/N):		nte: *	\$		Run Star Stop	17	R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr D4005	Revi B	ision Nbr	· · · ·								OAS	-
100 Waterjet FLOW CNC Waterje	et	Memo 1-Cut as per Dwg Rev: Prog Rev:	Dwg (D4005-13)	9.00		Λ		Ц			05 95 9-8	13 · B B
110		2-Deburr if a QC2- Inspect parts off m		0.00	50	n (,			DAS	
110 QC Quality Control		Memo	,	0.00				4			<u>န-</u>	13.03.05

												DQA:	Date	:
NCR: Y	es	/ No					WORK ORDER NON-C	O	NFORI\	IANCE / UP	DATE	OA Classel	Data	
•						_	Marine .	_				QA Closed:	Date	··
Nork Orde	r:					1	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	Part No.					Scrap Machining Small Fab			Crosstube Small Fab	Pro	Engineering Quality			
NCR N	lo						Use-as-is Work Order Update	Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier						Other
Root					Desc	rip	tion of work order update	Ī	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup other rocess upplier raining		•												
		·		<u> </u>			F	AUL	T CATE	GORY				
Landir	ng G	iear					General		-			- 1	_	
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Grain Hardware Inspection Incomplete Instructions Incomplete Maintenance		/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	{	Inspection	-	Tuhe			Cut Too Short	\vdash	Mislabe Misreac		-	Power Loss/		Other
		Ripples in		. 000	-		Drill Holes		Offset			رد د د د د د د د د د د د د د د د د د د	J	1
	-	Torque W		xtrusion	, F	_	Drawing	\vdash	4	Calibration				
1	Turning Sequence Finish Out of Sequence													

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

140

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

98049

Page 2

Tuesday, March	h 05, 2013 10	:47:31 AM			"98U2							Page 2
Item ID: Revision ID: Item Name:	D4005-041 Fwd Floor Gutter			*N9000401						Setup Star	* * N	S1* S2*
Start Date: Required Date Reference:	3/5/2013 e: 3/13/2013	Start Qty: 4.00 Req'd Qty: 4.00	·	*4* *4*		Cust Item I Customer:	ID:					
Approvals:	Process Pla	an:	Date:		Tooling: SPC (Y/N):		ate:		F	Run Star Stop	I <i>N</i>	R1*
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC8- Inspect parts - seco	ond check		0.00	l			4			
130 * 13 0*		Bend as per dwg			0.00				1.1			S
Brake NC Brake NC		Memo Bend D4005	5-13 as per E	Owg	0.00				4			. 13

0.00

NCR:	Yes / No	WORK ORDE

		DQA:	Date:	 ,	
ORK ORDER NON-CONFORMANCE / U	PDATE			,	

									QA Closed:	Date	:
Work Orde	·r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N								Engineering Quality Other			
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup						٠.					
Other [ļ	
Process											
Supplier											
Training										İ	
Unapproved		<u> </u>	<u> </u>	<u> </u>							
					F	AULT CAT	GORY				
Landin	ng Gear				General			_	7	_	_
	Bending				Bend	Grain			Ovalized	L	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	— —	tion Incomplete	<u></u>	Part Incorre	⊢ -	Weld
	Crushed/Crimped. Burrs			 	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs Contamination		Maint	enance		Part Moved					
	Heat Trea	ət			Countersink	Mislab	eled		Positioned \		
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea		<u> </u>	Power Loss,	/Surge	Other
Ĺ	Ripples in	n Bend			Drill Holes	Offset					
Į	Torque W	Vaves in E	xtrusio	n L	Drawing	Out of Calibration					
ļ	Turning S	equence			Finish	Out of Sequence					
i	Wave/Twist in Tube Folio			Outsid	e Dimensions						

Page 3

Tuesday, March 05, 2013 10:47:31 AM Item ID: D4005-041 Accept *N900040100* **Revision ID:** Fwd Floor Gutter Item Name: **Start Date:** Start Oty: 4.00 3/5/2013 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 3/13/2013 **Customer:** Reference: **Process Plan: Approvals:** Date: Tooling: Date: QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ 3 Tool ID Tool # Plan **Work Center ID** Description **Run Hours** 141 Weld per dwg A/R Aluminum rod Batch: 0.00 *141* Large Fab 0.00 Memo 1- Weld D4003-13 tube to angle as per dwg D4005 Large Fab 2- grind flush as per dwg 142 QC9- Inspect visual per QS1004- Fusion Welds 0.00 *142* QC 0.00 Memo Quality Control 143 QC5- Inspect part completeness to step on W/O 0.00

Run

Stop

Accept Code Qty

Reject Oty

Reject Number

Insp. Stamp

QC

Memo

0.00

Quality Control

Setup Start

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

_			$\sim M$
	fot .	Date (3/04/01	DOA JUTZ
•	,	· · · · · · · · · · · · · · · · · · ·	

									•	QA Closed:	Date:	13/2/0
Work Order:	941	19			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.	Part No. <u>D 4005-041</u> NCR No. <u>13-2413</u>				Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing			Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality X Other
Root				Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	13/3/10-	# 4	×Ч	theet (D)	en may, mistrons Dus by mistrons 13. 13. 13. 13. 13. 13. 13. 13. 13. 13.	0AS 16 3-5 3/3/17	(3)	Sh.	S H3hr	13318	15/242 AS/242 B/3/15	
Landing	Gear				General			/ /				
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	X	Instruct Mainte Mislabe Misread Offset Out of 9	ion Incomplete cions Incomplete/ enance eled d Calibration Sequence	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Wave/Twist in Tube Folio			Folio		Outside	Dimensions					

Tuesday, Marc	n 03, 2013 -10):47:31 AM									
Item ID: Revision ID:	D4005-041			Accept	*N900	040	100)* s	etup Sta	IV	S1*
Item Name:	Fwd Floor G	utter							Sto	$^{\mathrm{pp}}$ *N	S2*
Start Date: Required Date Reference:	3/5/2013 e: 3/13/2013	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item l Customer:	ID:					
								F	Run Sta	rt *N	D / *
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:			Sto) N	KI
	QC:		Date:	SPC (Y/N):	D	ate:			510	* *N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		Chemical Conversion C	Coat per QSI005 4.1	0.00							
150 HandFinish Hand Finishing		Memo		0.00							-
155 *155 *		QC7-Inspect Chemical	Conversion Coat	0.00							
QC Quality Control		Мето		0.00							
*160 *160*		Gloss Grey (4.3.5.15) p	per QSI 005 4.3	0.00							
Powder Coating		Memo Start Time Oven Tem	perature:	0.00							
Powdercoat		Start Time	perature:	0.00							

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-		NFORN	/ANCE / UP	DATE					
												QA Closed:	Da	ite:	
Work Ord	er:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
						Rework]		Skid-tube	Crosstube			Water Jet		Engineering
Part f	۷o.	<u> </u>				Scrap			Machining	Small Fab	\Box		d. Eng. Coor.	-	Quality
NCR I	NCR No.			·	Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Rec/Store/Packaging Supplier			Other			
Root					Descri	ption of work order update		nitial	Ac	ction		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	'n	QC Inspector
Doc/Data									İ					Ì	
Equip/Tooling]								١				
Operator									I			•			
Material									I					ł	
Setup									I						
Other	L_								l		ŀ				
Process	L						1		}						
Supplier															
Training		j									-				
Unapproved		<u> </u>		<u> </u>	<u>.</u>		<u> </u>		L						
						F	AUL	T CATE	GORY						·
Landi	ng (Gear			_	General					_			_	1
		Bending				Bend		Grain				Ovalized			Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route Hard			re			Over/Under	tolerance	\perp	Temperature/Cure
	L	Cracks Broken/Damaged						Inspecti	on Incomplete			Part Incorre	ct	L	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	it		-	Countersink		Mislabeled			Positioned Wrong		_		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	ı			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Want	Ondon	IT	98049
WUIK	Oruei	ענו	フロリサン

Quality Control

98049

Page 5

Tuesday, Marc	h 05, 2013 10	0:47:31 AM		*98I							
Item ID: Revision ID:	D4005-041			Accept	*N900	040			etup Start		S1*
Item Name:	Fwd Floor G	utter							Stop	*N	S2*
Start Date: Required Date	3/5/2013 e: 3/13/2013	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Reference:			_					_			
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:		F	tun Star	1/7	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center	ID -	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		QC3- Inspect Part Finish	h	0.00							
170 QC Quality Control		Memo		0.00				,,			·
190		Identify as per dwg & S	tock Location:	0.00							
100 Packaging Packaging		Memo		0.00							
200		QC21- Final Inspection	- Work Order Release	0.00							
200		Memo		0.00							

W13.03.21

												DQA:	Date:	
NCR: Y	'es	/ No				١	WORK ORDER NON-C	O	NFORN	AANCE / UP	DATE	QA Closed:	Date:	·
						T	DISPOSITION				AGAINST DE			
Work Orde	er: .							,		 1	,	1		,
Part No.			Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other					
NCR N	10.						Work Order Update	ork Order Update Large Fab Composite Supplier]	
Root		D-1-	Chara	04	Desc		on of work order update		nitial		tion	Sign & Date	Verification	QC Inspector
Cause	_	Date	Step	Qty	<u> </u>	orı	Non-conformance	Cn	ief Eng	Desc	ription	Date	vernication	QC IIIspector
oc/Data quip/Tooling Operator														
Naterial			1											
etup														
ther			ļ											
rocess														
upplier														
raining											•			
Inapproved														
							F.	AUL	T CATE	GORY				
Landi	ng (Gear			_	_	General	_	,			٦	_	¬
		Bending			<u> </u>	_	end		Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric to (D/S		OM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			L	B	roken/Damaged		1 '	on Incomplete		Part Incorre	 	Weld
		Crushed/	Crimped.			_	urrs	Instructions Incomplete/Unclear		'Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs					ontamination	Maintenance			Part Moved			
		Heat Trea	-			_	ountersink	untersink Mislabeled			Positioned V		7	
		Inspection	n Strip in	Tube	L	—	ut Too Short		Misread	I		Power Loss/	'Surge	Other
		Ripples in	Bend		Ĺ	D	rill Holes	L	Offset					
		Torque W	aves in E	xtrusion	۱ [D	rawing	Out of Calibration						
		Turning S	equence			TFi	inish		Out of 9	Seauence				

Outside Dimensions

Wave/Twist in Tube

Piçklist Print

Tuesday, March 05, 2013 10:47:30 AM

Work Order ID:

98049

Parent Item:

D4005-041

Parent Item Name:

Fwd Floor Gutter

Start Date: 3/5/2013

Required Date: 3/13/2013

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 10.01.21 new issue Prelim EC verified by:DD

IPP Rev:B 10.05.03 as per ECN10-

	562 DD verified b	y:EC IPP Rev	C 12.0	3.07 as per dv	vg rev.b DD v	erf: EC	us per Ber	110					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4003-13 Fwd Fuel Gutter Line		Manufactured	No			141	Each	0.0000	1	4			
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	706.7261	0.42	1.768421	1 M	1 13:03:	05
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT021		706.726126							
				121	099	273.7156							
				123	874	433.010526							

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
										QA Closed:	Date:	
Work Order	·:			· · · · · · · · · · · · · · · · · · ·	DISPOSITION				·	PARTMENT/	_	,
Part No	t No			Rework Scrap		N	Skid-tube Crosst Machining Small	Fab		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR No	o				Use-as-is Work Order Update]	Thermoforming Finishing Large Fab Composite			Rec/3tol	Supplier	Other
Root				Descri	ption of work order update	Ini	tial	Action	•	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Description		Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material etup other rocess upplier raining												
napproved		<u>. l , ,</u>	<u> </u>		F	ΔΙΙΙΤ	CATE	GORY				
Landin	g Gear				General							
	Bending Centre f Cracks Crushed Cuffs Heat Tre Inspecti Ripples	Bending Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Bend BoM/Route Broken/Damaged Contamination Countersink Cut Too Short Drill Holes		H In In N N N O	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
-	Turning Sequence Drawing			\vdash	Out of CalibrationOut of Sequence							

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

DART AEROSPACE LTD	Work Order:	98049
Description: Fwo Floor Gutter	Part Number:	D 4005-041
Inspection Dwg: 04005 Rev: B		Page 1 of 1

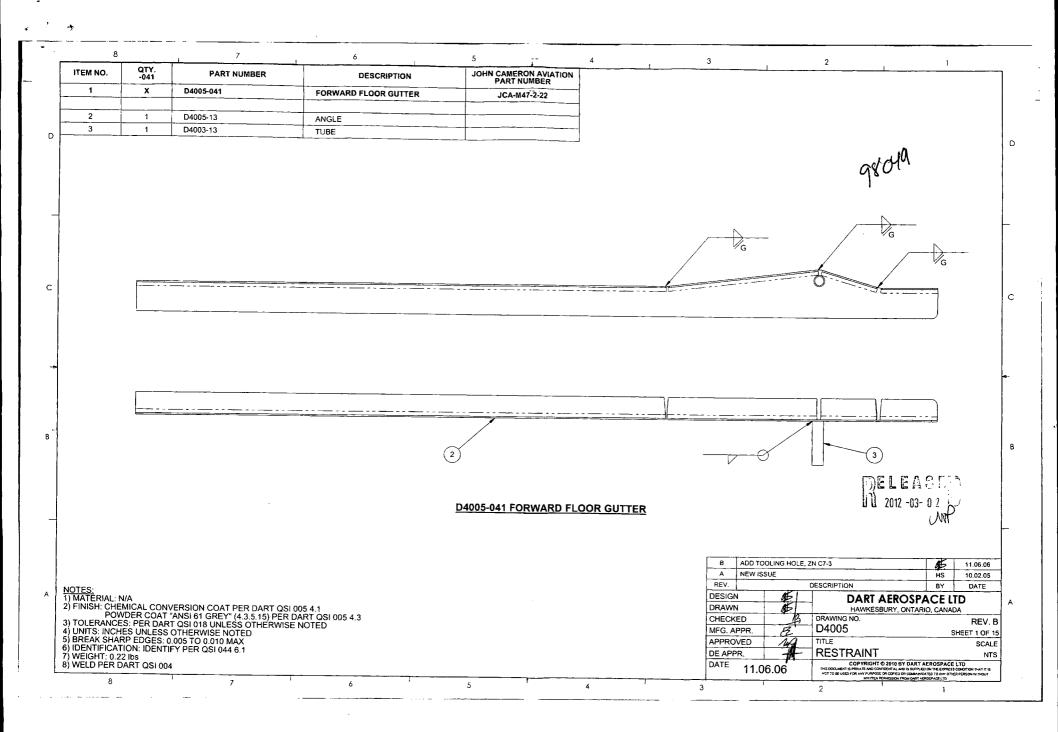
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$ 0.375	+10:005-0:001	0.375	1		NWN	MM-01
4.00	+1-0.010	3,991	<u> </u>		NMN	MM-01
26.77	H-0.030	26.75	✓		M.T	MM-02
1.67	H-0.030	1.67	V		VWV	MM-01
9.08	+1-0.030	9.08	√		M.T	MM-02
4.12	H-0.030	4.12	/		M.T	// 🤨
3.70	+1-0.030	3.70	√		MT	/ n
1.87	+1-0.030	1.87	\checkmark		VWN	MW-01
:						

Measured by:	7/1/	Audited by:	Preliminary Approval:
Date:	13.03.05	Date: /3 3 1/	Date:
		<u></u>	

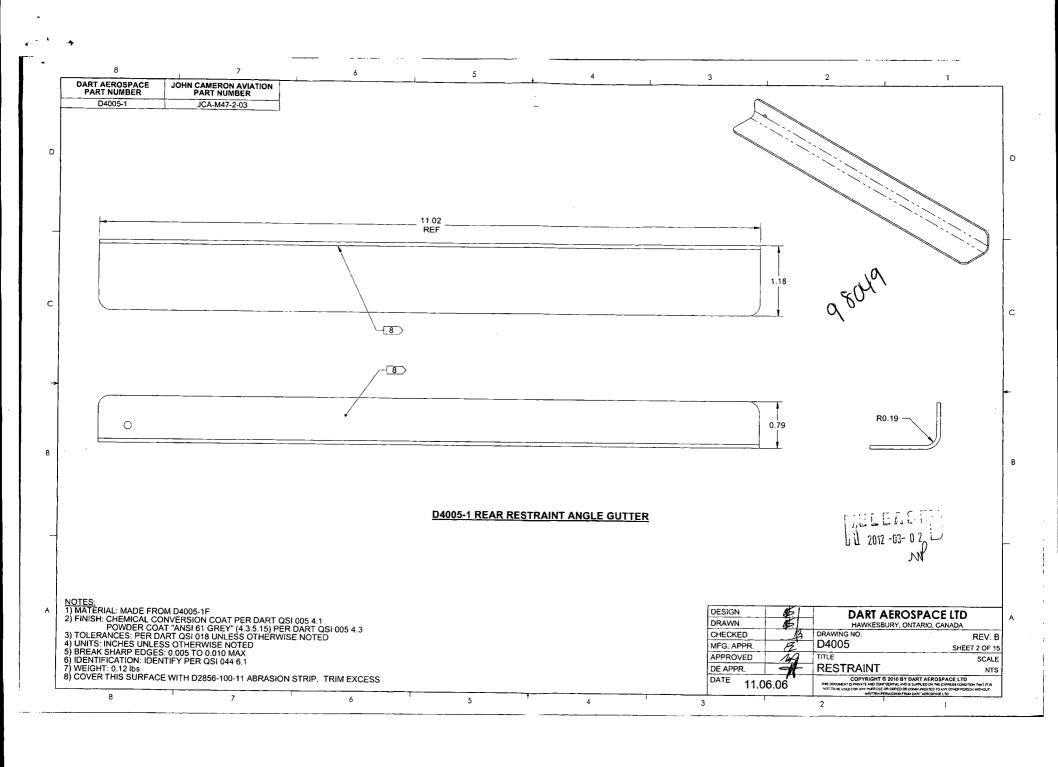
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15



DQA: Date:

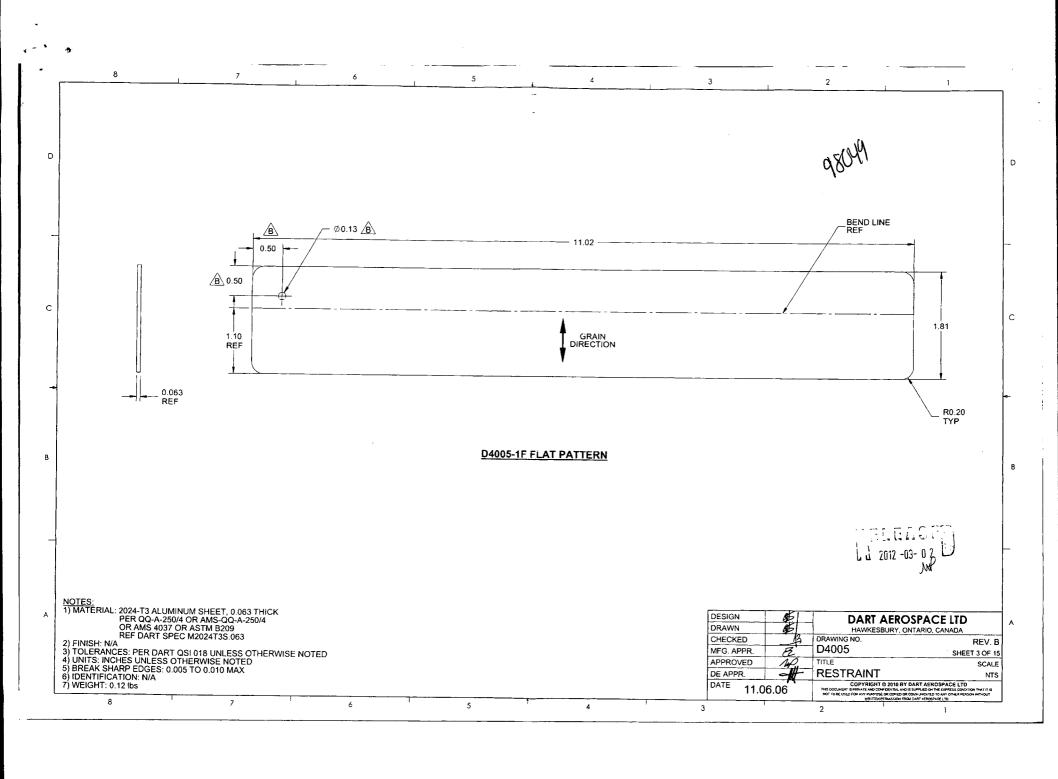
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
									-		QA Closed:	Date:		
Nork Orde	r:	- · · · · · · · · · · · ·		•		DISPOSITION			AGAINST DEPARTMENT/PROCESS					
	•					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.					Scrap	' []		Small Fab	(d. Eng. Coor.	Quality		
						Use-as-is			Finishing	Rec/Store/Packaging		Other		
NCR N	lo.					Work Order Update			Large Fab	Composite]	Supplier		
Root					Descri	iption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector	
oc/Data	_													
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ther														
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upplier														
raining				1					:					
Inapproved							FAU	LT CATE	GORY			<u> </u>		
Landi	ng (Gear		· · · · · · · · · · · · · · · · · · ·		General								
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		inspect	ion Incomplete		Part Incorre	ct	Weld	
		Crushed/	Crimped.			Burrs		Instruc	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	nt			Countersink		Mislab	eled		Positioned \	Wrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	'Surge	Other	
		Ripples in	Bend			Drill Holes		Offset					- W	
		Torque W	/aves in E	xtrusio	n [Drawing		Out of	Calibration					
		Turning S	equence			Finish		Out of	Sequence					
		Wave/Tw	ist in Tub	ре		Folio		Outside	e Dimensions					



	100		,	81 -
۱۱	ICR:	Yes	/	No

DQA: ____ Date: _____

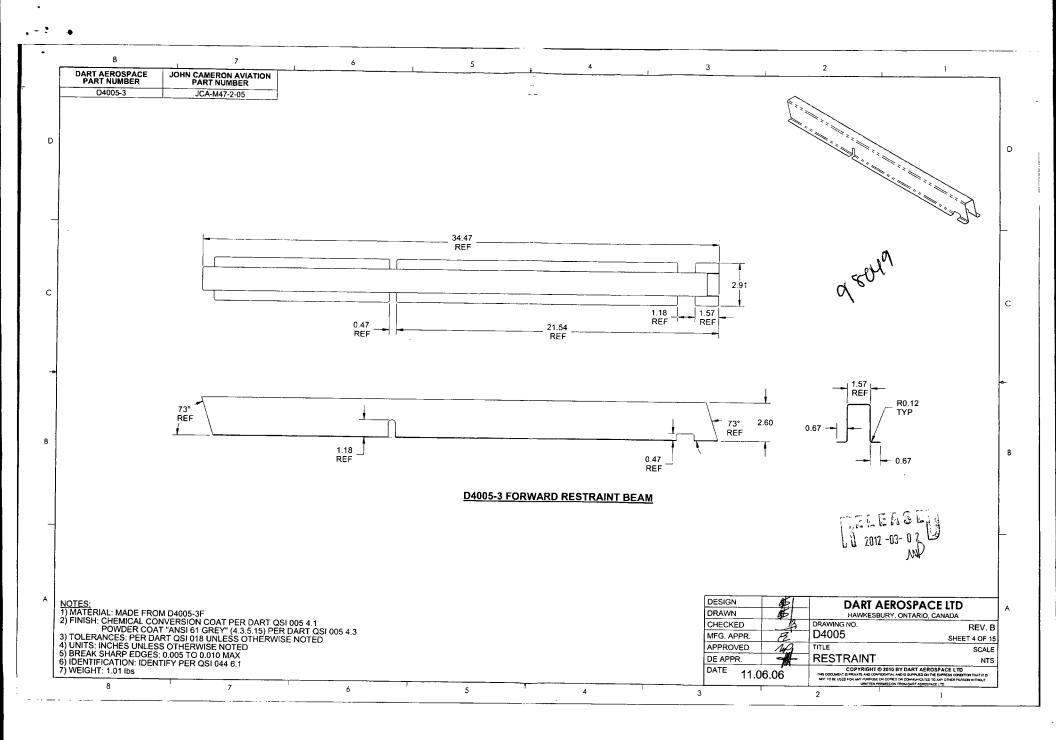
NCR: Y	es	/ No				WORK ORDER NON-C	CON	IFORN	MANCE / UPI	DATE	QA Closed:	Date:	•	
					"	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Nork Orde	r: _					Rework	7 		Skid-tube Crosstube Water Jet Eng				Engineering	
Part N	ο.					Scrap	1						Quality	
NCR N	lo.			·····		Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite		Rec/Stor	e/Packaging Supplier	Other		
Root					Descri	ption of work order update	11	nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
oc/Data	_													
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Inapproved			l	[<u> </u>		AUL	T CATE	GORY					
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	_	Bending			ſ	Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete	[Part Incorre	ct	Weld	
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs	·			Contamination		Mainte	nance		Part Moved		_	
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong		
Ì		Inspection 1	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other	
		Ripples in	Bend		<u> </u>	Drill Holes	Offset							
	Torque Waves in Extrusion Drawing			Out of Calibration										
		Turning S	equence	nce Finish Out of Sequence										
				Outside Dimensions										

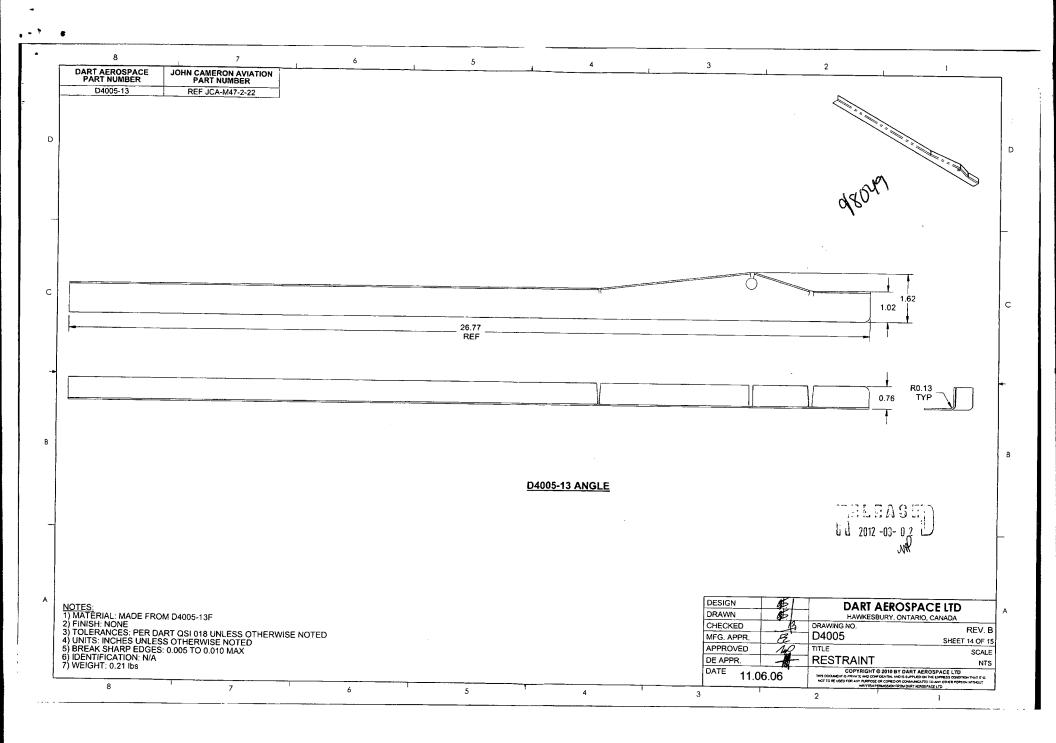


NICO	V	/ 81-
NCR:	Yes /	No.

DQA: _____Date: _____,

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UPI	DATE	QA Closed:	Date	:	
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No.					Rework Scrap Use-as-is	ap Machining S		Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No.					Work Order Update] ''''	Large Fab	Composite	Supplier			
Root		1 1 1			ption of work order update	Initial	i		Sign &	_		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Eng Description		Date	Verification	QC Inspector	
Doc/Data	_											
Equip/Tooling	_								ļ			
Operator]										
Material			İ									
Setup												
Other												
Process												
Supplier Training												
Unapproved	-											
Onapproved		<u> </u>	L	<u> </u>	F	AULT CATI	GORY		<u> </u>	<u> </u>		
Landin	ng Gear				General		*					
.[Bending				Bend	Grain	Grain		Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S				BOM/Route	Hardw	Hardware		Over/Under tolerance		Temperature/Cure	
Ī	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorrect		Weld	
	Crushed/Crimped.				Burrs	Instruc	ctions Incomplete/	Unclear	Part Lost/Missing		Wrong Stock Pulled	
	Cuffs				Contamination	Maint	enance		Part Moved			
	Heat Treat				Countersink	Mislab	eled		Positioned \	N rong		
	Inspection Strip in Tube				Cut Too Short	Misrea	Misread		Power Loss/Surge		Other	
Ī	Ripples in Bend				Drill Holes	Offset	Offset					
Ī	Torque Waves in Extrusion				Drawing	Out of	Out of Calibration					
Ī	Turning Sequence				Finish	Out of	Out of Sequence					
	Wave/Twist in Tube				Folio	Outsic	Outside Dimensions					





3 D BEND LINE BEND LINE REF REF 9.08 4.12 R0.38 BEND LINE TYP **—** 3.70 BEND LINE 0.70 **-** 1.88 С REF, TYP - - 1.87 -GRAIN DIRECTION 2.22 2.26 1.67 0.97 1.25 REF 0.040 Ø0.375 -REF R0.20 26.77 -TYP **D4005-13F FLAT PATTERN** В NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.040 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.21 lbs CHECKED DRAWING NO. REV. 8 D4005 MFG. APPR. SHEET 15 OF 15 APPROVED TITLE SCALE DE APPR. RESTRAINT NTS DATE 11.06.06 COPYRIGHT © 2010 BY DART AEROSPACE LTD
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